

CHUCK



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

DSK081

Job Sheet 201975



Part No: DSK081

Job Qty: 6 pcs

Part Name: D2940-1 Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/19

Job Tracking No:

Due Date: 11/28/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV B IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					Hrs	Hrs			
100	Doosan - 1	6 pcs	11/28/19	11/28/19	0.20	6.82	Doosan - 1		JBD 11/10/25
110	QC 2	6 pcs	11/28/19	11/28/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		JBD 11/10/25

Plex 10/17/19 9:05 AM Dart.lajeunesse.marie

120 QC 8	6 pcs	11/28/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	SBL 19/10/26
				QC 8 - 76	
				QC 8 - 61	
130 Packaging 3-1 - Stock - B4B	6 pcs	11/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	6 pcs	11/28/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	4-3P

Part Op 100 - (Doosan Lathe) Turn blank as per Folio FA079

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____) LOCATION: MAT060
 140 - (QC21- Final Inspection - Work Order Release)

NOV 01 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6104-007	Round Billet, 17-4	6 pcs (1 ea)	100-Doosan - 1	5173261

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	D6104-007	6	16	0

Part Specifications	
Specifications could not be found.	

Plex 10/17/19 9:05 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 201975
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	1 Go/No Go Gauge	2 *	3 *	4 *	5 *	6 *
Lathe Section								
A	3.211	3.216	3.216	3.216	3.2163	3.2175	3.220	3.215
B	4.946	4.966	4.958	4.958	4.957	4.946	4.956	4.956
C	0.718	0.738	0.722	0.725	0.725	0.725	0.720	0.725
D	0.090	0.110	0.105	0.105	0.110	0.105	0.105	0.105
E	3.564	3.584	3.573	3.574	3.574	3.576	3.576	3.573
F	0.022	0.042	0.032	0.032	0.032	0.032	0.032	0.032
G	3.444	3.464	3.453	3.453	3.453	3.456	3.455	3.4525
H	0.112	0.132	0.119	0.120	0.117	0.117	0.117	0.118
I	2.170	2.190	2.180	2.178	2.175	2.178	2.177	2.171
J	4.451	4.471	4.460	4.463	4.459	4.461	4.463	4.462
K	0.413	0.433	0.416	0.418	0.420	0.413	0.420	0.420
L	0.913	0.933	0.925	0.920	0.930	0.929	0.927	0.921
M								
N								
O								
P								

Measured by: TRD DAS	Date: 14/10/25
Audited by: 57 9-89	Date: 14/10/26
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	201975
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**

 ☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216						
B	4.946	4.966						
C	0.718	0.738						
D	0.090	0.110						
E	3.564	3.584						
F	0.022	0.042						
G	3.444	3.464						
H	0.112	0.132						
I	2.170	2.190						
J	4.451	4.471						
K	0.413	0.433						
L	0.913	0.933						
M								
N								
O								
P								

Measured by:	Date:
---------------------	--------------

Audited by:	Date:
--------------------	--------------

Prototype Approval:	Date:
----------------------------	--------------

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation				Disposition			
Completed By				Lead hand / Supervisor			
QC / QA Coordinator							

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Bending ☐ Misaligned/off center ☐ Crushing ☐ BOM/Route ☐ Cracks ☐ Broken/Damage/Defect ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Marks/Chatter ☐ Drill Holes ☐ Mislabeled ☐ Fit/Function ☐							
	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐								
	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐								
		Other/Details:							